

Slip 18/05

Date: Thursday, 5/10/2007 2:23:46 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 32271	
Estimate Number : 12719	
P.O. Number : <u>NIA</u>	Part Number : D353625
This Issue : 5/10/2007 S.O. No. : <u>NIA</u>	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : <u>NIA</u>	Material : <u>NIA</u>
Written By : _____	Due Date : 5/17/2007 Qty: 4 Um: Each
Checked & Approved By : <u>18.05.10</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6254 sf(s)/Unit Total : 2.5015 sf(s)
NEOPRENE SHEET 0.063
Batch: 116364

5AD 07/05/12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3536
Dwg Rev: A
Prog Rev: A

8AD 07/05/12

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5AD 07/05/12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

86 07.05.12

4

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

7/10/14/159

④

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/05/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32271

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07105/14

Job Completion



11 07-05-14

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

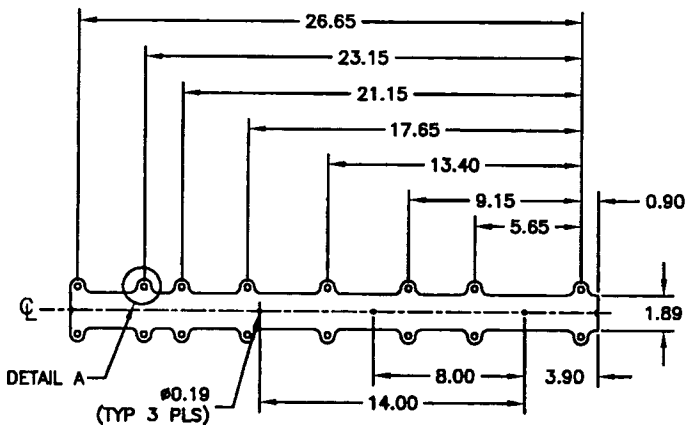
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

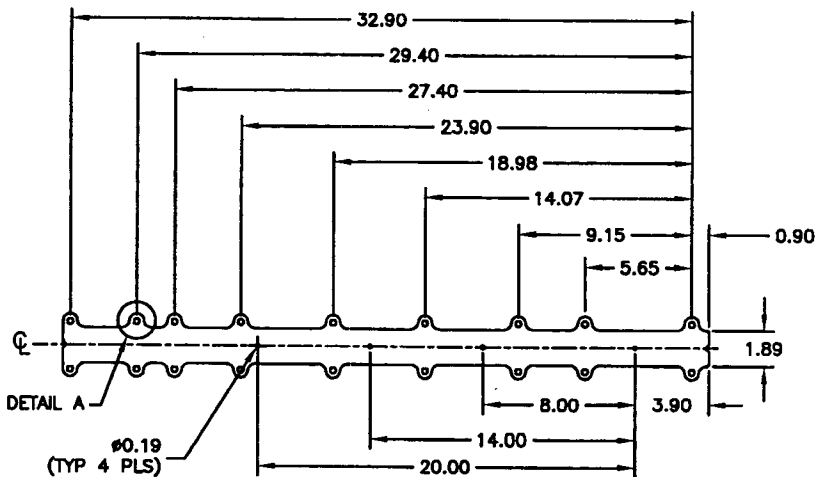


RELEASED
09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AT	APPROVED	AT	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE



D3536-11 GASKET




D3536-13 GASKET

NOTES

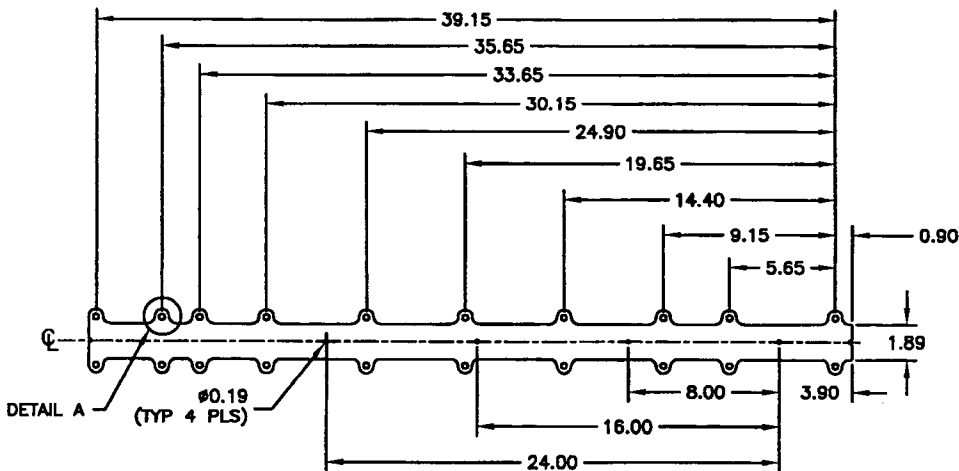
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WITHOUT NOTICE
WORK ORDER
NO. 32271

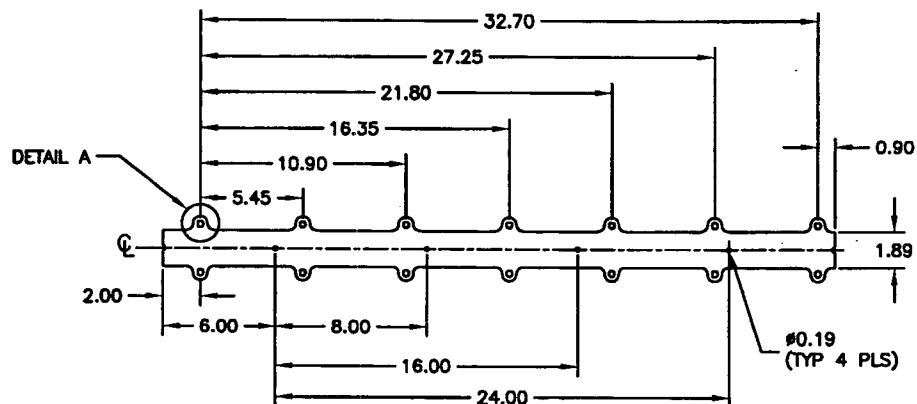
DART

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CHECKED	PH	APPROVED		DRAWING NO.	D3536
DATE	06.10.25	TITLE	GASKET	REV. A	SHEET 2 OF 6
				SCALE	1:10

07.02.12



D35.36-15 GASKET



D3536-21 GASKET

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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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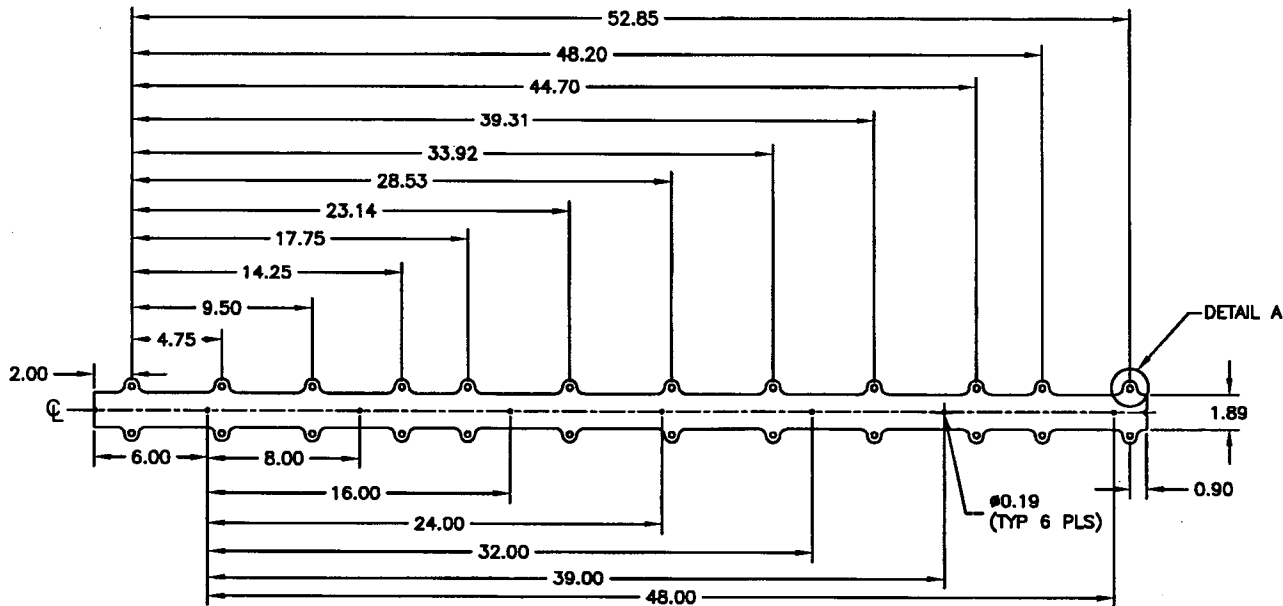
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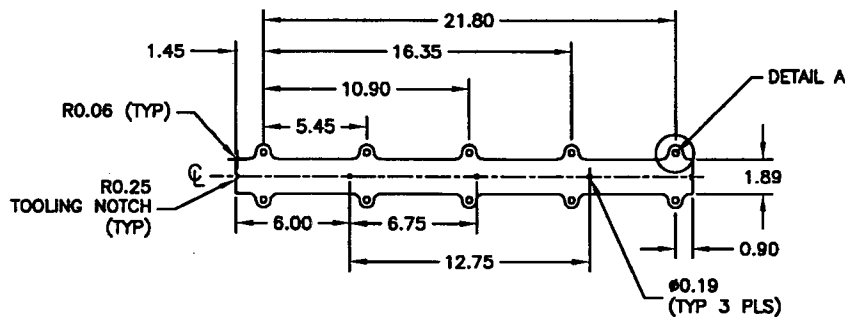
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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07-02-12



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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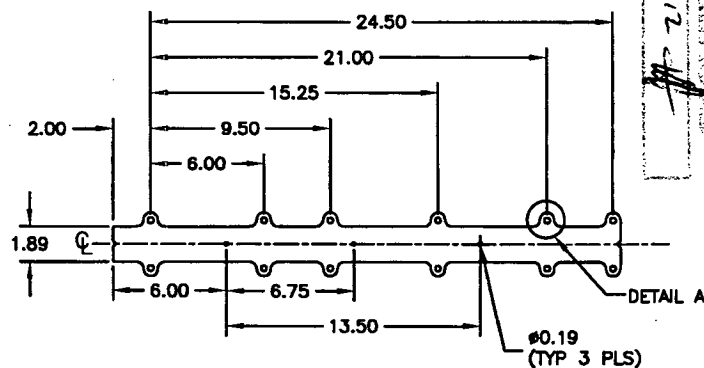
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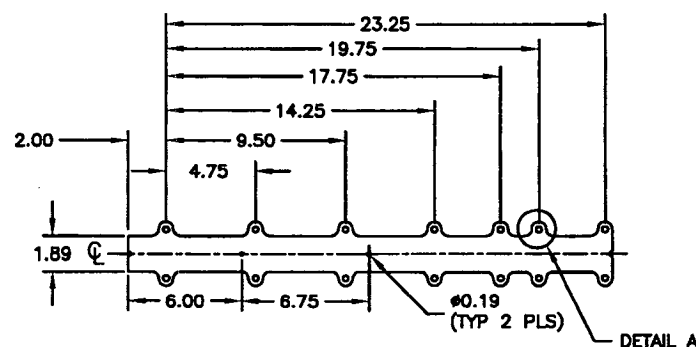
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

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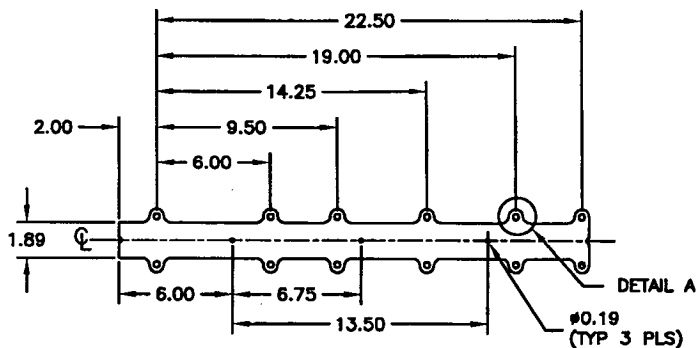
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

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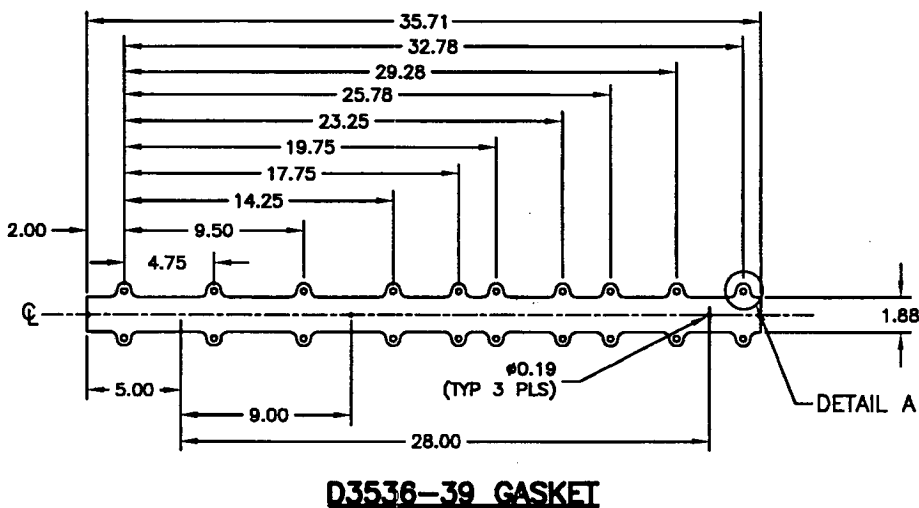
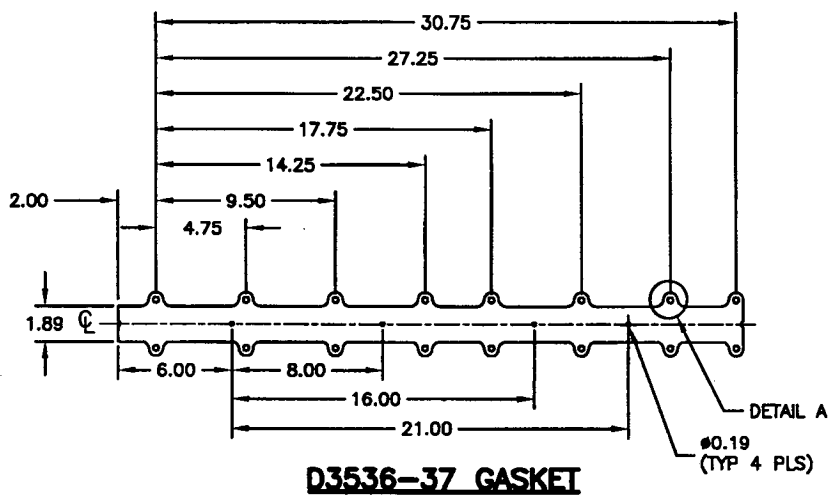
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DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6
	SCALE 1:10	

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NOTES

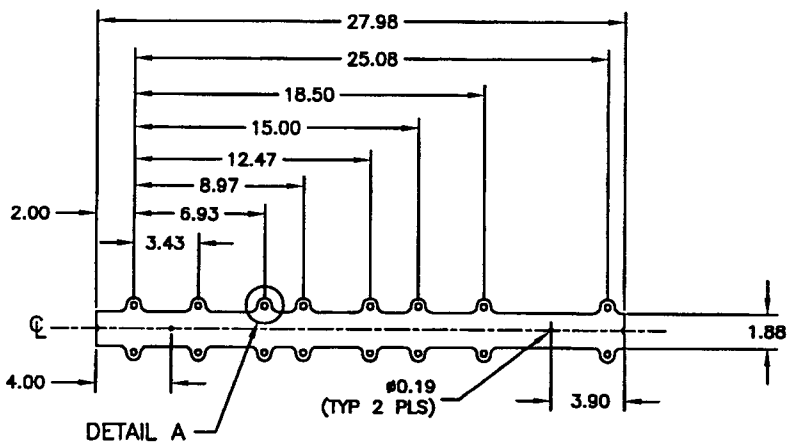
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ART

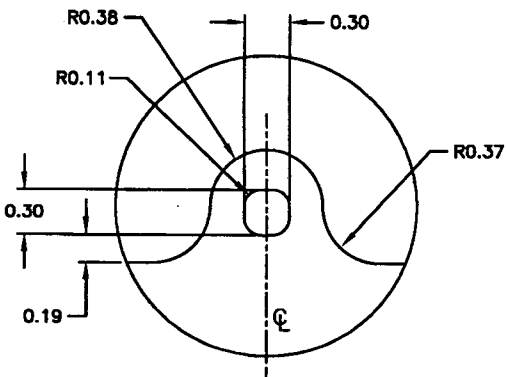
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10

070212-4



D3536-41 GASKET

DETAIL A



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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NO. 32271

DART AEROSPACE LTD		Work Order: 32271
Description: Bearing GASKET		Part Number: D353625
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	21.80	+/- 0.030	21.80	✓		M-T	
B	16.35	+/- 0.030	16.35	✓		M-T	
C	10.90	+/- 0.030	10.90	✓		M-T	
D	5.45	+/- 0.030	5.45	✓		Vern	
E	1.45	+/- 0.030	1.45	✓		Vern	
F	6.00	+/- 0.030	6.01	✓		Vern	
G	6.75	+/- 0.030	6.74	✓		Vern	
H	12.75	+/- 0.030	12.74	✓		Vern	
I	0.90	+/- 0.030	0.91	✓		Vern/height gauge	
J	1.89	+/- 0.030	1.89	✓		Vern	
K	0.20	+/- 0.030	0.30	✓		Vern	
L	0.30	+/- 0.030	0.31	✓		Vern	
M	Ø0.19	+/- 0.030	Ø0.200	✓		Vern	
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: JAD	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/05/12	Date: 07-05-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	